

PROJECT TITLE : SPECIFICATIONS / PROCESS ASSURANCE

Period Covered : 28.11. - 24.12.1980

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Report Approved By: J.B. Boder

0. SPECIFICATIONS - OVERALL

0.1 Weight of cigarette seam glue - refer to point 5.2.

0.2 Test with standardized tobacco weights and AccuRay limits - refer to point 5.1.

1. SPECIFICATIONS PER PRODUCTION CENTER PME

1.1 FTR Neuchâtel

Minor modifications.

1.2 INM SpA Zola Predosa

1.3 PMH Eindhoven and Bergen op Zoom

Minor modifications.

1.4 PMG Munich and Berlin

- Except for Lark, a 21 mm filter plug is used on all King Size cigarettes. On most of these brands, the width of the tipping paper has been increased from 24 to 25 mm.
- A situation table has been drawn regarding the production of diluted and non-diluted Marlboro MLK DB cigarettes in Berlin and Munich.
- A new packing version, PMS 205 Ph. Morris Super Lights, for sale in Guadeloupe - Ile-de-réunion, has been produced.

1.5 WELTAB Bruxelles

- Following Mr Fauville's visit in Neuchâtel, several specs modifications as well as the specs for production at Jubilé, Liège BE, of the present Welta King Size cigarettes, are in preparation.

1.6 PM UK London

- The tobacco moisture at the new Legg cutter has been modified in PM UK's processing specification.

1.7 PM Nigeria, Ilorin

- Following the distribution of the newly updated complete PMN specs file, a long list of modifications has been sent in by MPP PME on the one hand and by PMN on the other hand.

1.8 Licensees

- Austria:
A completely reviewed specs file for the production of MLF Marlboro Filter at Austria Tabakwerke, Vienna, has been distributed.
- DDR, Dresden:
A completely reviewed specs file for the production of MLF Marlboro Filter at VEB Dresden has been distributed.
- Finland:
Following the discussions held with Mrs Byckling and Mr Rosimo, ATO Hyrylä, as well as with Mr J. Rae, most of the Finnish specs file has been redone. Details on modifications see separate report.
- Italy:
A proposal regarding standardized cigarette moistures at packing has been addressed to Mr A. Trento.
- Holland:
The tear tape quality of four packing versions produced with Laurens BV, The Hague, has been corrected. Following C. Flury's visit there, all processing, filter making, and cigarette making and most packing specifications of Ed. Laurens BV will have to be redone (new blends and filter length increase from 20 to 22 mm).
- Switzerland:
The modifications in the specs of Ed. Laurens SA Geneva (blends, filter length increase, etc.) will concern most of their specs sheets. The list of modifications will be available by the end of January, 1981.
- Great Britain:
Manchester Tobacco Co., producing MLK Marlboro King Size under contract of PM UK London, as well as L & M cigarettes, have asked if their L & M cigarette sizes

could be brought in line with the MLK sizes. A situation report has been drawn for the intention of Mr J. Rae.

2. MATERIAL SPECIFICATIONS

2.1. Approvals by suppliers

P FM/O36 semi-filter FLI 33.9010 & charcoal pilote 11184 from Baumgartner.

2.2. An MPP + QA Coordination meeting has taken place in Lausanne on December 11, 1980. See minutes issued.

3. PME STANDARD RECIPES

Preliminary information has been provided to FTR and PMG regarding the future Super Juice recipes. As from about mid February, a semi-manufactured mixture will be used for the Super Juice, instead of the present 6 individual ingredients.

4. SPECIFICATIONS ON EDP

During the work session of December 16, 1980, it has been decided that C. Flury and C. Cotting will document the current business situation and evaluate the possibilities of computer support for PME specifications, between January 7, and February 27, 1981.

5. PROCESS ASSURANCE

5.1. AccuRay (References 1 to 4)

- It has been decided to carry out an industrial test of three months' duration, as from beginning January, 1981. This test is linked to tobacco weights standardized for brands which have practically the same blend. See also point 5.9. below.
- Each production center will start the test beginning January with

- Lower mean weight limit : - 2,5 %
- Lower limit cigarette rod : - 10 %
of tobacco weight
+ NTM weight

Some of the parameters might have to be modified during the test period so as to guarantee a good product quality.

- Special recommendations have been addressed to Weltab and PMH Eindhoven, which have no computer available, so as to be able to collect a maximum of information.

5.2. NTM Non-tobacco Material Weights (Reference 7)

- Following the different trials made, it has been decided that a weight of 1,5 mg. should be foreseen for the glue on the cigarette seam (for all brands). This information has been passed to all production centers, who will adopt this weight when establishing making specifications in the future.
- We are still waiting for certain results regarding the "Determination of the quantity of glue on the tipping paper".
- Following a visit in FTR Cousset, it has been decided that the following tests will be made in January, 1981 :
 - Determination of quantity of glue on filter (inner and seam glue)
 - Determination of the quantity of glue on cigarette seam, when liquid glue is used
 - Determination of the quantity of glue on the tipping paper.

5.6. Burley Treatment

This study is still pending. We shall wait for the two primaries in Berlin and Bergen op Zoom to become operational, so that the data available can be completed.

5.7. Kitchen and Pre- and After-cutting Solutions

Same remark as for point 5.6.

5.9. Tobacco Weights (References 1 and 2)

The proposal to standardize the tobacco weights at 12% moisture has been approved. The new tobacco weights are based on a fix density on the one hand, and on the composition of the blends on the other hand.

The brands concerned are Marlboro (MLF - MLH - MLK) and Merit (MER).

5.10. New Primary Bergen op Zoom and Berlin (Reference 5)

Upon request of QA Bergen op Zoom, some recommendations have been addressed to PMH regarding the important parameters to be respected during tobacco processing, as well as

the moistures and temperatures which should be aimed.

5.11. Standard Recipes

This check is still pending.

5.12. Project Fortuna (Reference 6)

A detailed program regarding the trial planned beginning 1981, has been addressed to the project leader.

Thierry Bel

T. Bel

Catherine Flury

Flury

Anne-Marie Kopp

a.k.o/h

References

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|--------------------------------|-------|------------|
| 1. Memo to J. Gibson | dated | 1.12.1980 |
| 2. Memo to QA managers | " | 5.12.1980 |
| 3. Memo to H. Fauville, Weltab | " | 9.12.1980 |
| 4. Memo to J. de Haas, PMH | " | 9.12.1980 |
| 5. Memo to J. de Haas, PMH | " | 22.12.1980 |
| 6. Memo to J.L. Débétaz, PME | " | 17.12.1980 |
| 7. Memo to QA managers | " | 15.12.1980 |